

Work Order ID 110121

December-17-13 9:15:34 AM

110121

Page 1

Item ID: D3793-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Fwd

Start Date: 12/17/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-12-13

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

13 0 Jm14-1-9

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

13 0 Jm14-1-9

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27

4/1/9

13

Work Order ID 110121

December-17-13 9:15:34 AM

110121

Page 2

Item ID: D3793-1 Accept *N19000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Fwd
Start Date: 12/17/13 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							14/01/13
130	NC BRAKE					13			DAS 36 9-89
Brake NC	Memo	0.00		DAS 30 9-89					
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793								
140		0.00							
140	QC5- Inspect part completeness to step on W/O	0.00				13			
QC	Memo	0.00		DAS 27 9-89					
Quality Control									
150		0.00							
150	Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3	0.00				13			DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:20 FINISH TIME: 2:50 OVEN TEMPERATURE:								

Work Order ID 110121

December-17-13 9:15:34 AM

110121

Page 3

Item ID: D3793-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Fwd
 Start Date: 12/17/13 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				B			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: PP.002 Memo	0.00 0.00				x13	4	20	14/01/15
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14-01-15 @ 14-01-15

Picklist Print

December-17-13 9:15:33 AM

Page 1

Work Order ID: 110121

Parent Item: D3793-1

Start Date: 12/17/13

Required Date: 12/17/13

Parent Item Name: Wearplate Fwd

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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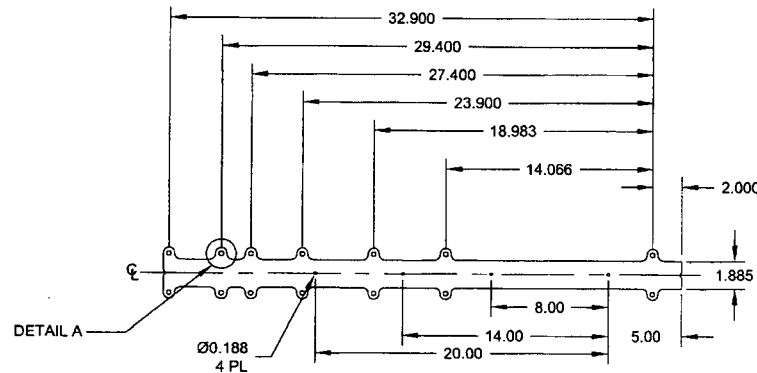
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	436.3000	0.5902	7.4551584			
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	436.30001	
m125754	24.17001	
m126852	111.13	
m127454	301	

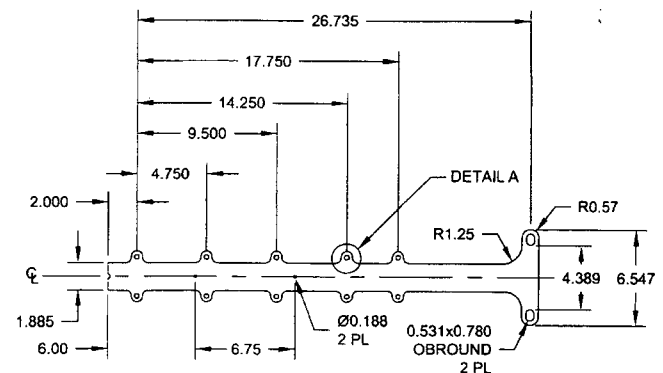
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Im 14-1-9

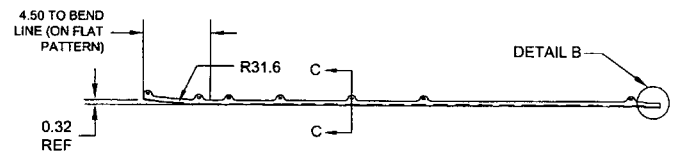
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

110121 MJS
13-12-19

RELEASED
08-05-14

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
 - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN			BY	DATE
DRAWN	PH			
CHECKED	PH			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

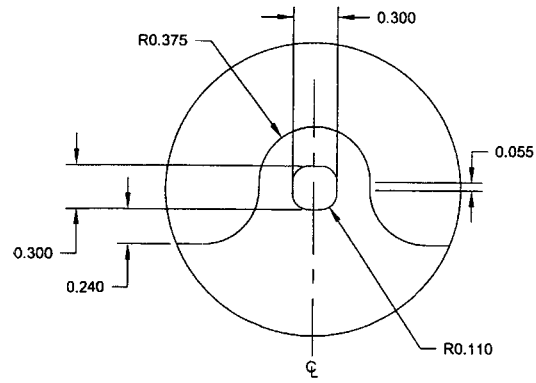
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3793
TITLE WEARSHOE
SCALE NTS

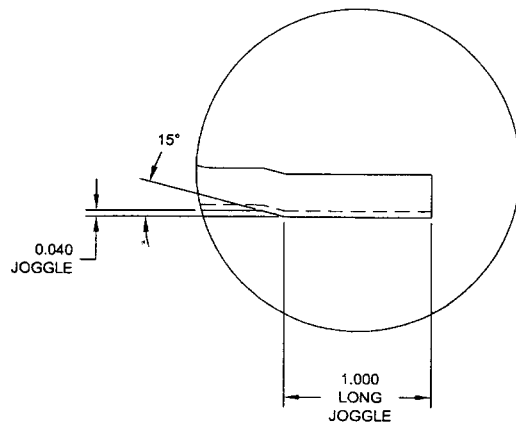
REV. A
SHEET 1 OF 2

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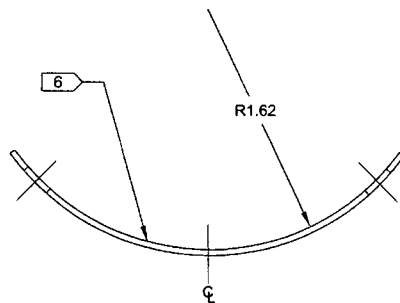
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-23

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1